

Shit

Work Order ID 61521 - 2

Monday, August 30, 2010 10:17:15 AM

Page 1

Item ID: D3414-041

Revision ID:

Item Name: Lug Assembly

Start Date: 8/30/2010

Start Qty: 24.00

Required Date: 9/3/2010

Req'd Qty: 24.00

Reference:

Approvals: Process Plan: *mf*

QC:

Date: 10-8-30 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3414

Rev C

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3414-1

Dwg Rev: *S*

Prog Rev: *S*

2-Deburr if necessary

0.00

10-8-31

(35)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

10-8-31

Work Order ID 61521

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Page 2

Item ID: D3414-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug Assembly

Start Date: 8/30/2010 Start Qty: 24.00

Required Date: 9/3/2010 Req'd Qty: 24.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

8/10/08/31

counted
(435)



QC

Memo

Quality Control

0.00

130

0.00



Brake NC

Memo

0.00

SD 10/08/31

35

Brake NC

1-Deburr

2-Form using DT8254 as per Dwg D3414

140

0.00



Large Fab

Memo

0.00

EL 10-9-23

(27)

Large Fab

1- Weld using location Jig DT8484 as per Dwg D3414
A/R. S.S. welding rod Batch: M101744

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61521

Monday, August 30, 2010 10:17:15 AM



Item ID: D3414-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 8/30/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 9/3/2010 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

(27) P10.05.23

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Scolor 123

count
427

165



SprayPaint

Spray Painting

Spray Painting per QSI005 4.2

0.00

Memo

Prime B _____
Spray paint Delfleet Blue B _____
Clear Delfleet B _____

white gloss

Start: 1:55

Finish: 2:25

temp at 400°

Per QSI005
M115291.

MF
10-9-23

BL 10-10-5. (27)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61521

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Item ID: D3414-041

Revision ID:

Item Name: Lug Assembly

Start Date: 8/30/2010 Start Qty: 24.00

Required Date: 9/3/2010 Req'd Qty: 24.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

175



QC

Quality Control

Operation
Description

QC14- Inspect Spray Paint

QC 3

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



Packaging

Packaging

Identify as per dwg & Stock Location: 474

Memo

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/10/05

27 0

10/10/07 5A 270

10/10/12

mf 10-10-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, August 30, 2010 10:17:14 AM

Page 1

Work Order ID: 61521



Parent Item: D3414-041

Parent Item Name: Lug Assembly

Start Date: 8/30/2010

Required Date: 9/3/2010

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP A. 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S12GA



304/316 0.100" Sheet

Purchased

No

100

sf

204.1000

0.155

3.72

5.5

HB(6-8-31)

Location

Loc Qty

Loc Code

MAT19

204.1

112290

15.1

112611

29

113062

128

113077

32

112290

(35)

D3414-3



Lug

Manufactured

No

140

Each

12.0000

1

24



EL 10-9-22.

Location

Loc Qty

Loc Code

WA

12

61240

12

61537

22

61833

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

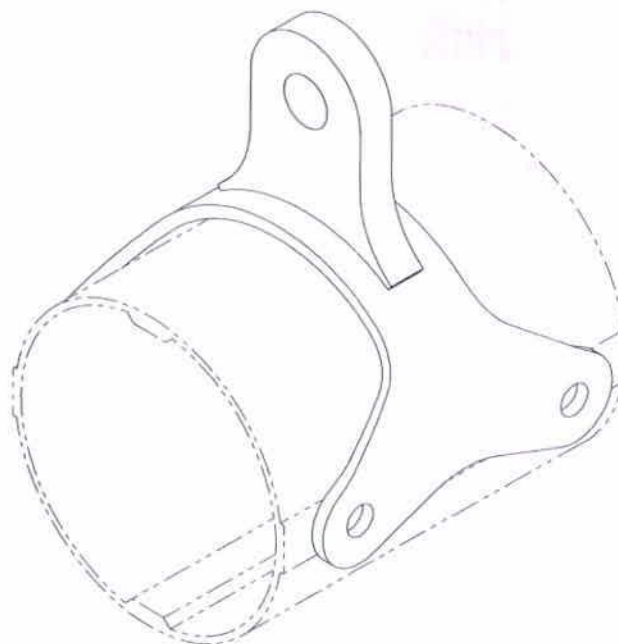
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

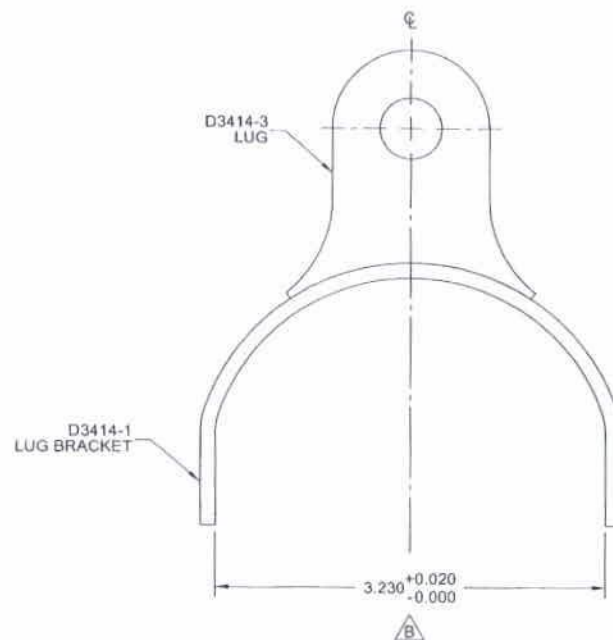
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

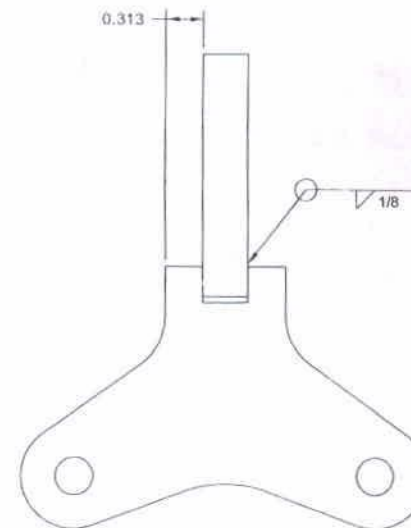
C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	J	DRAWING NO.	REV. C
MFG. APPR.	W	D3414	SHEET 1 OF 3
APPROVED	W	TITLE	SCALE
DE APPR.	W	LUG ASSEMBLY	NTS
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RELEASED
01/16/2017

61501

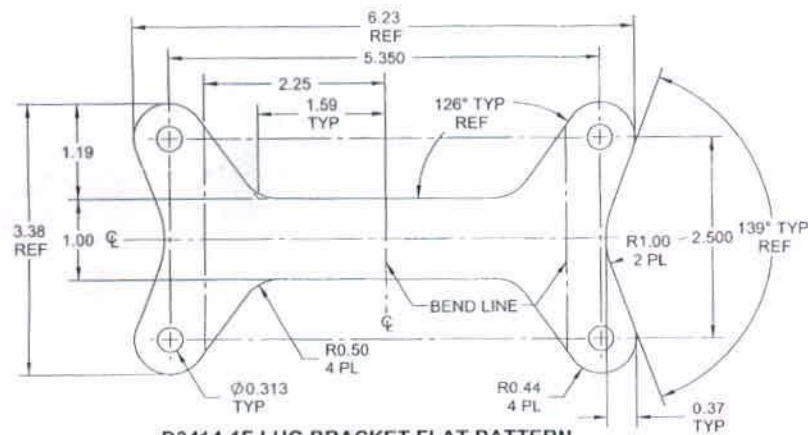


D3414-041 LUG ASSEMBLY

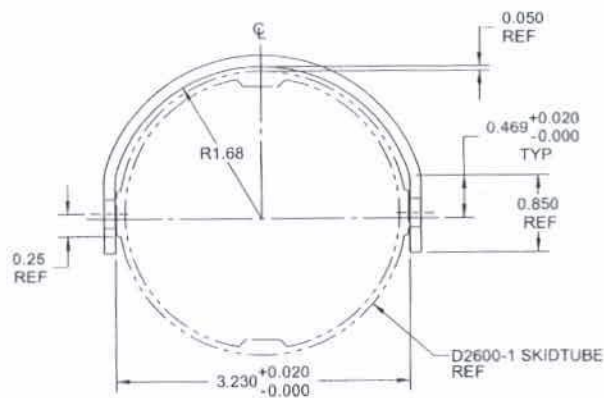


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04/18/16

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CHECKED	J	DRAWING NO. D3414	REV. C
MFG. APPR.	EJ	SHEET 2 OF 3	
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D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

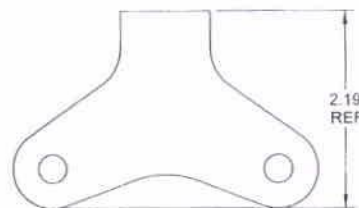
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

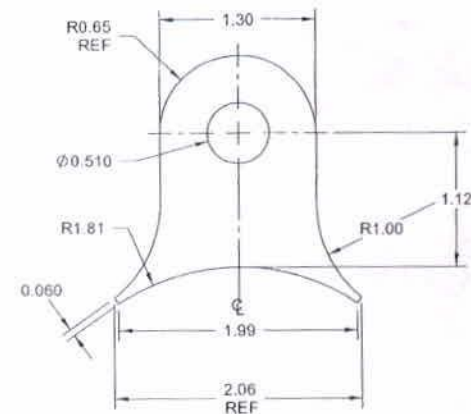
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A



SIDE VIEW FOR REF ONLY



D3414-3 LUG



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09/06/17

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DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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